

Work Order ID 87003

87003

Page 1

July 9, 2012 11:41:22 AM

Item ID: D209-669-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube
 Start Date: 7/09/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: CY Date: 12/07/09 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2906	Rev B (DEO)

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 003								

110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	- Inspect mat'l D2500-1-190 for damage								
	-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)								
	-Open holes to 0.500" as per Dwg D2906 without cutting fluid								
	-Deburr and blow out all chips from								
	-Acid etch and Alodine tube per QSI 005 4.1								

SAD
12-07-09

2/6 12-79

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Required Date: 7/20/12 Req'd Qty: 1.00 *1*

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Run Start *NR1*

Approvals: Process Plan: Date: Tooling: Date:

Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC3- Inspect Part Finish 0.00

120

QC

Memo

0.00

Quality Control

DP 12-7-9

130 Skidtubes 0.00

130

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expire date:

Start Time: 4:15

Fin Time:

pick:

Qty

P/N

description

1

D2926-3

Web

B/N

B86638

SAD 12-07-09

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Required Date: 7/20/12 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
140	BENDING MACHINE - CROSSTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT								
	2-Cut tubes as per Dwg. D2906								
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	-Deburr ends and remove marks from bending								
	- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.								
160		0.00							
160	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

DC 12/67/11

DC 12/07/12

DAS 18 12/07/12 +1

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00

170

Large Fab

0.00

Skidtubes

Memo

-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Debur

Skidtubes

-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Debur

-Drill pilot holes for Tow ring using DT9555 , open to .640" and Debur

OK 12/07/12

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

*DAS
16
9-8*

12/07/12

W/O:		WORK ORDER CHANGES					
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QC: Date: SPC (Y/N): Date:

Run Start ***NR1***

Stop ***NR2***

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200

Pressure Wash per QSI005 4.3

0.00

200

HandFinish

Memo

0.00

Hand Finishing

1 2/6 12-7-13

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

210

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:50
320°F
9:20

1X 12/07/13

220

QC3- Inspect Part Finish

0.00

220

QC

Memo

0.00

Quality Control

1X 11/07/13

W121841

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W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	<div>Memo</div> <div>1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 11121130 Sikaflex expire date: 14103</div> <div>2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906</div> <div>3-Inspect for foreign object per QSI 024</div> <div>4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 11121130 Sikaflex expire date: 14103</div> <div>5-Wing Walk as per Dwg D2906 and QSI 005 4.4 Batch: 1112505</div>								

16 16/ 11/04/12

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Start Date: 7/09/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

250

0.00

250

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-043

Location:

PPP Rev: PPP 84889

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Memo

0.00

Quality Control

12/17/12

12/17/18

MF

12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 87003

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 7/09/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

Comments: new IPP 08.02.13 LL, verified by: DD
IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 Spacer		Manufactured	No				Each	165.0000					
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						LG	125						
						77727	5						
						83263	3						
						84763	117						
						LG002	40						
						78806	6						
						79810	34						
D2500-1-190 Ext'n - I' Beam Tube 4"		Manufactured	No			110	Each	139.0000	1				
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						HALL	139						
						74777	9						
						80061	38						
						85483	92						
D2926-3 Web		Manufactured	No			110	Each	15.0000	1				
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						LG	15						
						84949	6						
						84950	2						
						86263	4						
						86446	3						

DL 12¹⁹/07/12
(9)

SAD 12-07-09

(7)

SAD 12-07-09

B86638 (1)

X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 87003

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 7/09/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 230 Each 3.0000 2 mt 12/07/16

Cap

Location

Loc Qty

Loc Code

FP002

3

B84952

x2

65519

2

73347

1

AN3-5A

Purchased

No

230

Each

779.0000

4

mt 12/07/16

Bolt

Location

Loc Qty

Loc Code

ST350

779

115371

46

117423

121

119355

200

120187

406

121185

6

x1

AN960JD10L

NAS1149D0332J

Purchased

No

230

Each

0.0000

4

mt 12/07/16

Washer

ALS7-1032-130

X

Purchased

No

230

Each

1,978.0000

44

mt 12/07/16

Insert

Location

Loc Qty

Loc Code

ST280

51

117717

27

118966

22

119775

2

ST282

1927

119530

73

120181

12

121444

1842

1112144

x44

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID: 87003
 Parent Item: D209-669-043
 Parent Item Name: Replacement Skidtube

Start Date: 7/09/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

230 Each 4,040.0000

44

44 11/07/16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	4040	
120187	31	
120521	28	
120769	38	
121205	111	
121556	8	
122151	3824	

AN960C10L washer X NAS1149C0332R Purchased No

230 Each 21.0000

44

44 11/07/16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	21	11122063
107534	21	

44

D2594-3 O-Ring, 205 Skidtube Manufactured No

230 Each 2,228.0000

14

14 11/07/16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	2228	
65518	41	
79496	984	
79573	50	
79755	1153	

44

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Start Date: 7/09/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

D2594-1 Manufactured No
Plug, 205 Skidtube

230 Each 1,363.0000 14

14 11/02/16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	84	
73401	30	
74442	6	
79495	48	
FP002	429	
85454	429	
FP-A	850	
73401	0	
78590	23	
84951	410	X 10
86391	417	

D3564-9 Manufactured No
Wearshoe

230 Each 28.0000 1

1 11/07/16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	4	
76950	4	B 85474
FP001	24	
67590	4	
69943	1	
82255	1	
84870	18	

D3564-11 Manufactured No
Wearshoe

230 Each 26.0000 1

1 11/07/16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	5	
77056	5	
FP001	21	
83910	17	X 1
84871	4	

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Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 230 Each 49.0000

Wearshoe

1 1 12/07/16

Location	Loc Qty	Loc Code
FG	2	
34806	2	
FP001	47	
80343	1	
82254	1	
84869	23	X 1
85475	22	

D3566-1 Manufactured No 230 Each 93.0000

Gasket

2 2 11/07/16

Location	Loc Qty	Loc Code
FP	-32	
FP002	125	
68924	2	
80919	2	
81619	3	
84879	61	X 2
86240	25	

D3566-5 Manufactured No 230 Each 64.0000

Gasket

1 1 12/07/16

Location	Loc Qty	Loc Code
FP	26	
82275	1	
86241	25	
FP002	38	
80374	1	
82274	6	
84881	31	X 1

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QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

RELEASED

07.09.04

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 1 OF 3
APPROVED	21	TITLE	SCALE
DE APPR.	21	AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

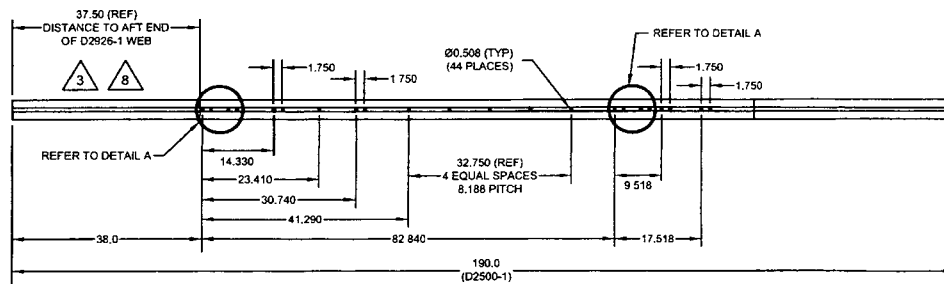
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

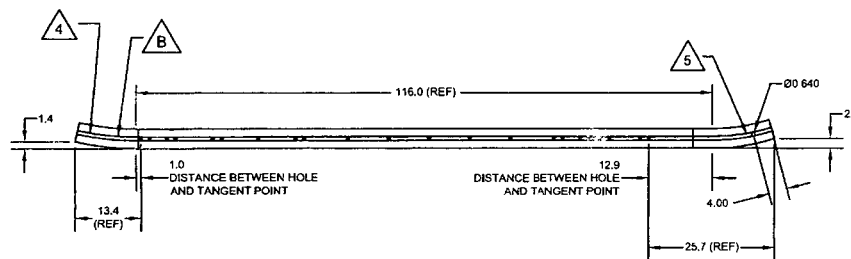
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

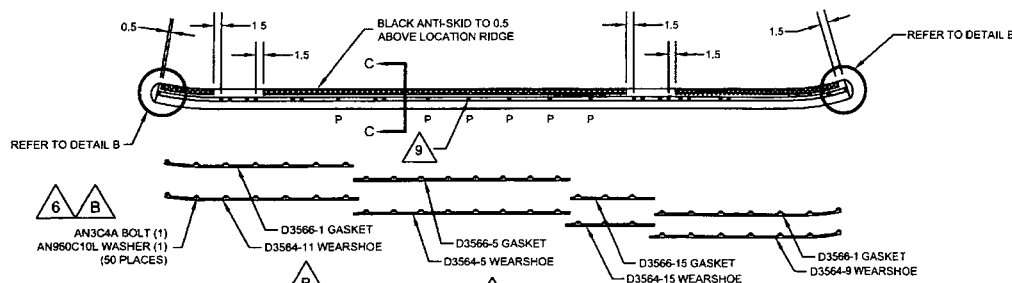
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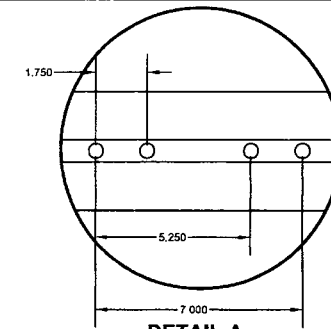
D2906-1 DRILLING DETAIL



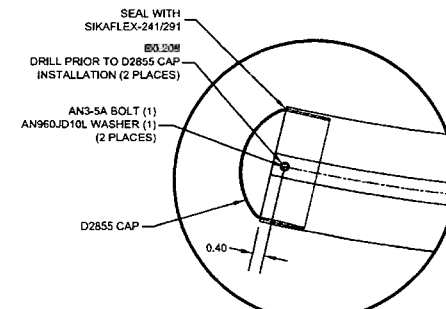
D2906-041 BENDING AND CUTTING DETAIL



D2906-041 ASSEMBLY DETAIL



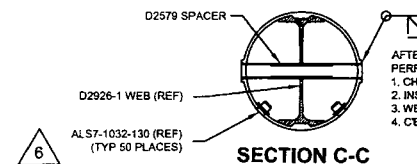
DETAIL A
SCALE 1:4



DETAIL B
SCALE 1:4

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07.09.04



SECTION C-C
SCALE 1:4

DESIGN	90	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D2906	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	AH-1 (209) SKIDTUBE ASSEMBLY	1:24
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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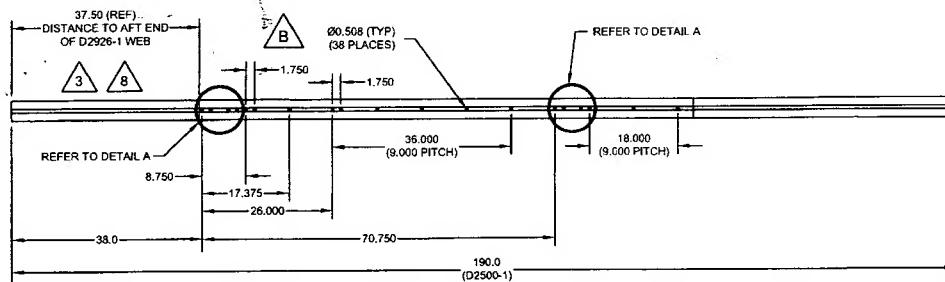
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

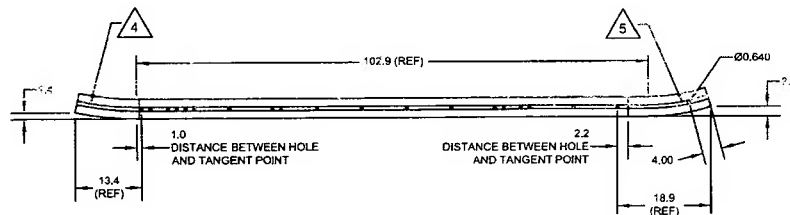
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

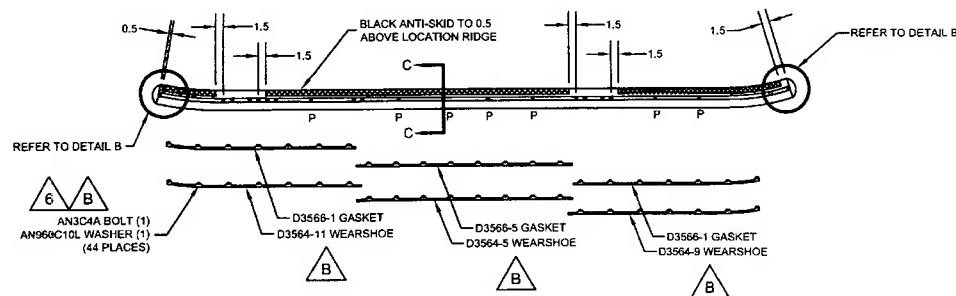
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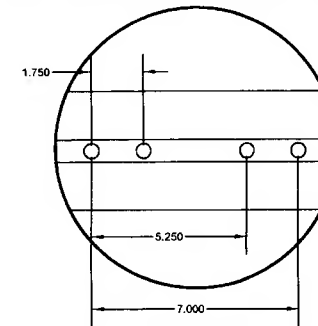
D2906-3 DRILLING DETAIL



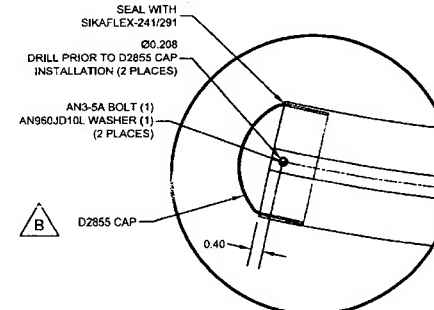
D2906-043 BENDING AND CUTTING DETAIL



D2906-043 ASSEMBLY DETAIL

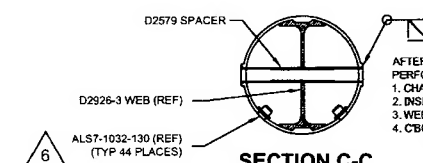


DETAIL A
SCALE 1:4



DETAIL B
SCALE 1:4

RELEASED
07.09.04



SECTION C-C
SCALE 1:4

DESIGN	9P	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D2906	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	AH-1 (209) SKIDTUBE ASSEMBLY	1:24
DATE	07.08.21	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMBINED WITH ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2906	TITLE AH-1 (209) SKIDTUBE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2906-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN A.P.	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.05.28	DATE 12.05.28	DATE 12.05.31	DATE 12.05.31		DATE 12.05.31		

PURPOSE:

CHANGE ALL C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

WAS

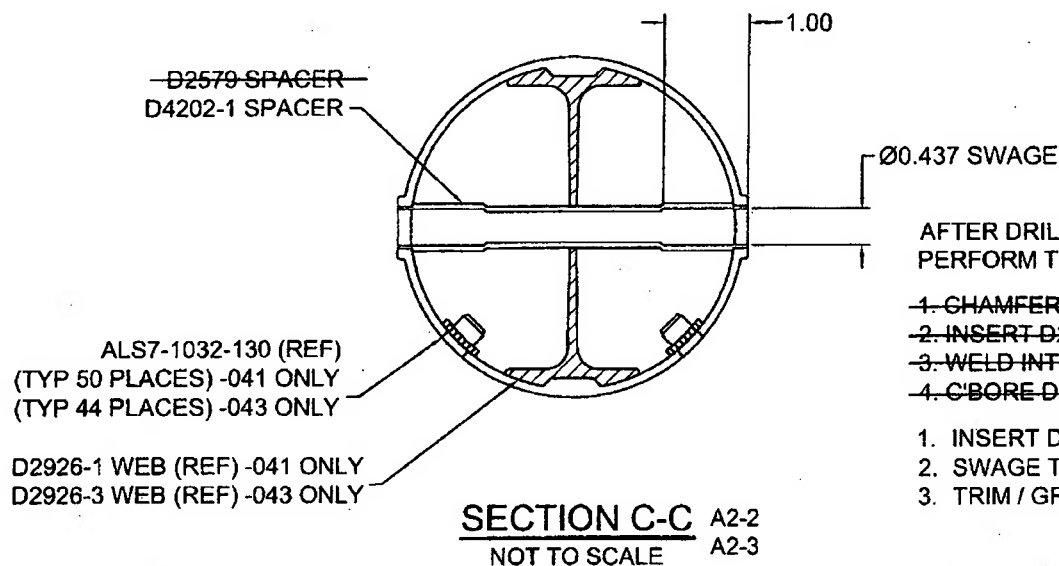
QTY -041	QTY -043	PART NUMBERS	DESCRIPTION
22	19	D2579	CROSS BOLT SPACER

IS

22	19	D4202-1	SPACER
----	----	---------	--------

SECTION C-C ON SHEETS 2 & 3 ARE AMENDED AS FOLLOWS FOR ALL HOLES THAT WERE ORIGINALLY C'BORED:

RELEASED
2012-06-05
[Signature]



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 22 PL (-041) OR 19 PL (-043)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries